

Date: Tuesday, 11/6/2007 1:12:25 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 6" MIRROR		
Job Number	: 35536		Part Number	: D2011101		
Estimate Number	: 10101		Drawing Number	: D2011 REV. F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/6/2007 S.O. No. : N/A		Drawing Revision	: F		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/20/2007		
Previous Run	: 34886		Qty:	50	Um:	Each
Written By			Comment			
Checked & Approved By			Comment			
			Comment			
			Comment			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: 4999 Purchase Grote Mirror P/N: 28043 Possible supplier: UAP/NAPA Material release note required		
1.0	28043	MIRROR 6"
Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Mirror 6"		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		
5.0	D30141	Locknut
Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Locknut Pick: Qty Part Number Description Batch		
1 D3014-1 Lock nut B25021		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2011-101 PAR #: N/A Fault Category: Prod / Proc Ass ^{prod & small} NCR: Yes No DQA: LD Date: 01/11/22
 QA: N/C Closed: SD Date: 02.11.23

NCR: <u>35536</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/11/14</u>	<u>49</u>	<u>one of the mirrors is not good the seal wasn't install well</u>	<u>SD</u>	<u>Scrap mirror</u>	<u>ml 07/16/14</u>	<u>SD</u>	<u>SD</u>	<u>SD</u>

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 1:12:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 6" MIRROR	
Job Number: 35536		Part Number: D2011101	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
6.0	AN960JD416L 	Washer	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) <i>48.49</i>			
Washer			
Pick:			
Qty	Part Number	Description	Batch
1	AN960JD416L	Washer	<i>M105408</i>
7.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1			
1- Discard Hardware & Install new hardware loosely			
2- Drill mirror using drill Jig DT8704 as per Dwg D2011			
3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.			
Qty	Part Number	Description	Batch
9ml	N/A	Sikaflex-291/-241	<i>M105488</i>
Expiry date		<i>07/2008</i>	
Start: <i>07/11/14</i>	Time: <i>3:30</i>	<i>x 48</i>	
Finish: <i>07/11/20</i>	Time: <i>12:00 noon</i>	<i>mul07/11/15</i>	
8.0	QC5 	INSPECT WORK TO CURRENT STEP	
<i>07/11/14</i>			
Comment: INSPECT WORK TO CURRENT STEP			
4- Test assembly to 50lbs pull test after 24 hours			
9.0	PACKAGING 1 	PACKAGING RESOURCE #1	
<i>07/11/20</i>			
Comment: PACKAGING RESOURCE #1			
Identify and Stock			
Location: <i>ST 227</i> <i>sf183 over</i> <i>07/11/21</i> <i>x48</i>			
10.0	QC21 	FINAL INSPECTION/W/O RELEASE	
<i>07/11/20</i>			
Comment: FINAL INSPECTION/W/O RELEASE			
Job Completion 		<i>07/11/21</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

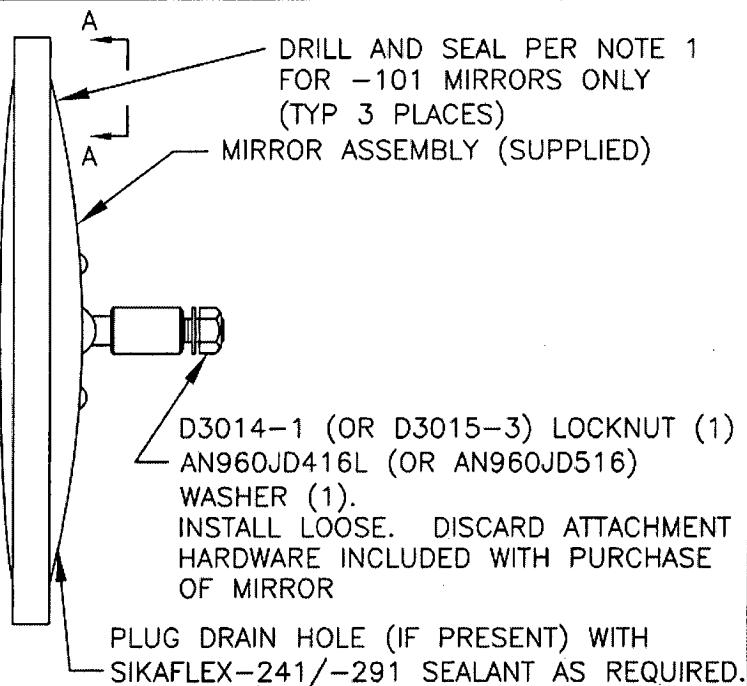
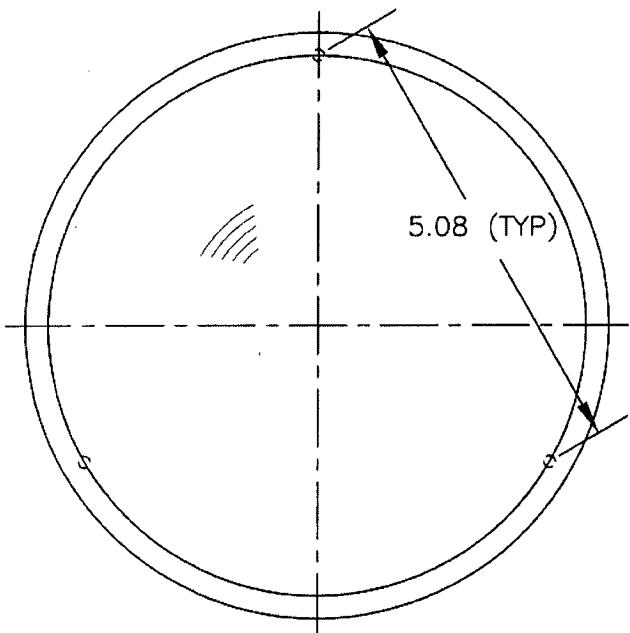
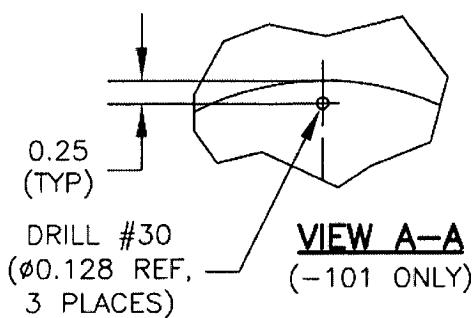
Part No: D2011-101 PAR #: N/A Fault Category: *Part / Proc. Ass'.* ^{most 50%} NCR: Yes No DQA: *D* Date: *07/11/22*
QA: N/C Closed: *AA* Date: *07/11/23*

NCR: <i>35532</i>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/14	7	<i>Brake 1 mirror when drilling</i>	<i>Initial 07/11/14</i>	<i>Scrap replace</i>	<i>No</i>	<i>ml 07/11/14</i>	<i>AA 07/11/20</i>	<i>D 07/11/20</i>

NOTE: Date & initial all entries

DARTDRAFT COPY IS
NOT FOR RELEASE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2011	SHEET 1 OF 1
DATE		TITLE	SCALE
04.09.10		MIRROR ASSEMBLY	1:2

RELEASED
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35536

NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

Copyright © 1990 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NAPA
 NEWKESBURY AUTO PARTS INC 5560G9TE: 861597896RT0001
 384 MAIN STREET WEST
 NEWKESBURY, ONT. K6A 2J2
 TEL: 632-8575 FAX: 632-1539

DANGEROUS GOODS PERMIT
 EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
 CANUTEC 613-996-6666

REC #	SOLD TO		DATE	TIME	STORE #	EMP #	INVOICE NO.
11	DART AEROSPACE LTD		11/12/07	14:44	060004074	31	180544
12	1270 ABERDEEN STREET						PURCHASE ORDER #
13	NEWKESBURY, ONTARIO						ATTENTION
14	100-1447						4999 4999.
							TAX EXEMPTION: 6122-5207
							TERMS: NET 30 DAYS CHARGE SALE
							DELIVERY:
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL	
	GRO	GROTE	50.00	41.140	16,820	841.00	T150

ITEMIZED BY

Subtotal 841.00

50.46

Tax 6% GST ONLY 0.00

Tax 0% 0.00

ITEMIZED BY

S. Union

SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

TOTAL -----> CHARGE SALE 891.46